

# Work Order ID 79924

February-08-12 9:24:10 AM

\*79924\*

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4456-5 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: ~~PRELIM~~ Stop \*NS2\*  
 Item Name: Center Raingutter  
 Start Date: 17/02/2012 Start Qty: 40.00 \*40\*  
 Required Date: 17/02/2012 Req'd Qty: 40.00 \*40\*  
 Reference: Cust Item ID:  
 Customer:

Approvals: Process Plan: MC5 Date: 12/02/08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4456	A

100

\*100\*

Waterjet

FLOW CNC Waterjet

6061-032

FLOW WATER JET

Memo

1-Cut as per Dwg  
 Dwg Rev: A  
 Prog Rev: A  
 2-Deburr if necessary

0.00

0.00

B12-2-22

(42)

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/IB

Memo

0.00

0.00

B12-2-22

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

12-02-22 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79924

**\*79924\***

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February-08-12 9:24:10 AM

Item ID: D4456-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: PRELIM Stop **\*NS2\***  
 Item Name: Center Raingutter  
 Start Date: 17/02/2012 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 17/02/2012 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	NC BRAKE	0.00							
Small Fab	Memo 1- Form as per dwg using DT9790 2- After forming cut off tabs as per dwg	0.00							
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 <b>*150*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

SA 12/03/15

12/03/15

20

5.2/03/15

cont  
+20

20 7/6 12-3-19

P/O

Punch:  
 issue P/O to meters for heat treat P/O 16523  
 need: need + inspect  
 11/13/30 20  
 12/03/22 20

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See NCR 12-1293

Part No: D4US6-5 PAR #: \_\_\_\_\_ Fault Category: Linda (see ncr) NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/4/05	150	Parts were sent out for heat treat when they were not supposed to. <u>yes.</u> P.C. <u>100 on shaper</u>	<u>h</u> 12/4/05	Scrap + Destroy No Repair	<u>h</u> 12-4-5	<u>h</u> 12/4/05	<u>h</u> 12/4/05	<u>h</u> 12/4/05

NOTE: Date & initial all entries

# Work Order ID 79924

**\*79924\***

Page 3

February-08-12 9:24:10 AM

Item ID: D4456-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: PRELIM Stop **\*NS2\***  
 Item Name: Center Raingutter  
 Start Date: 17/02/2012 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 17/02/2012 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00

**\*160\***

QC

Memo

0.00

Quality Control

20X1/ M-12/13/20

170 Identify as per dwg & Stock Location: \_\_\_\_\_ 0.00

**\*170\***

Packaging

Memo

0.00

Packaging

180 QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC

Memo

0.00

Quality Control

*[Handwritten signature]*

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

117-048

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

February-08-12 9:24:13 AM

Work Order ID: 79924

\*79924\*

Parent Item: D4456-5

\*D4456-5\*

Parent Item Name: Center Raingutter

Start Date: 17/02/2012

Required Date: 17/02/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 11.11.21 NEW ISSUE DD VERF:EC  
12.01.18 AS PER DWG REVa DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	221.3860	0.5	21.05263			

\*M6061T6S 032\*

6061-T6 Sheet 0.032"

\*\*

B12-2-22

Location

Loc Qty

Loc Code

MAT021

221.386

118106

54.106

120218

80.6

120285

86.68

170286

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

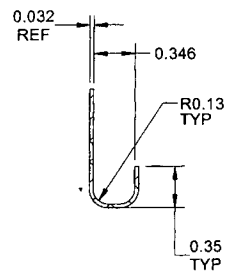
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

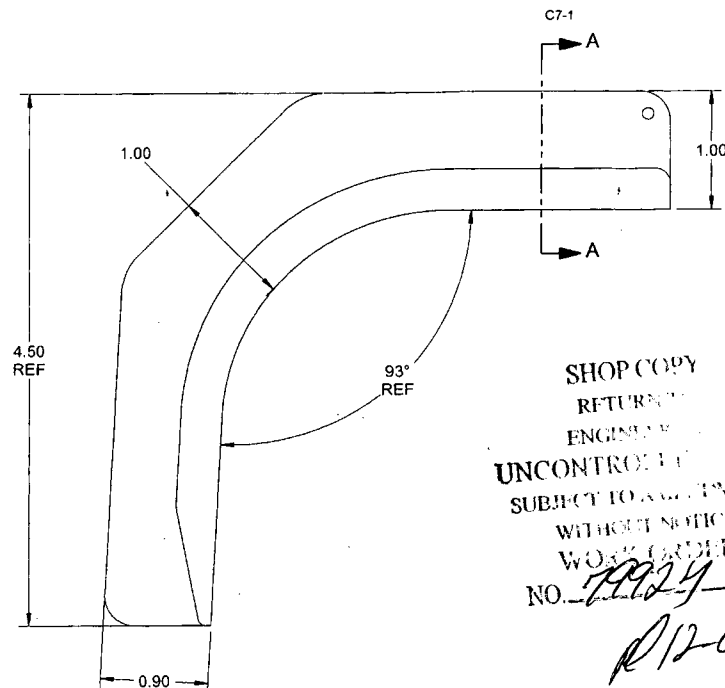
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**SECTION A-A** D4-1



SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED COPY  
SUBJECT TO ACCEPTANCE  
WITHOUT NOTICE  
WORK ORDER  
NO. *19924*  
*R12-02-7*

**D4456-1 FWD RAINGUTTER, LH**

**NOTES:**

- 1) MATERIAL: MAKE FROM D4456-1F FLAT PATTERN  
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

A NEW ISSUE		RF	11.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.11.17		

<b>DART AEROSPACE USA, INC.</b> KENT, WA		REV. A
DRAWING NO. <b>D4456</b>		SHEET 1 OF 8
TITLE <b>RAINGUTTER</b>		SCALE NTS

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R 2012-01-17  
*[Signature]*

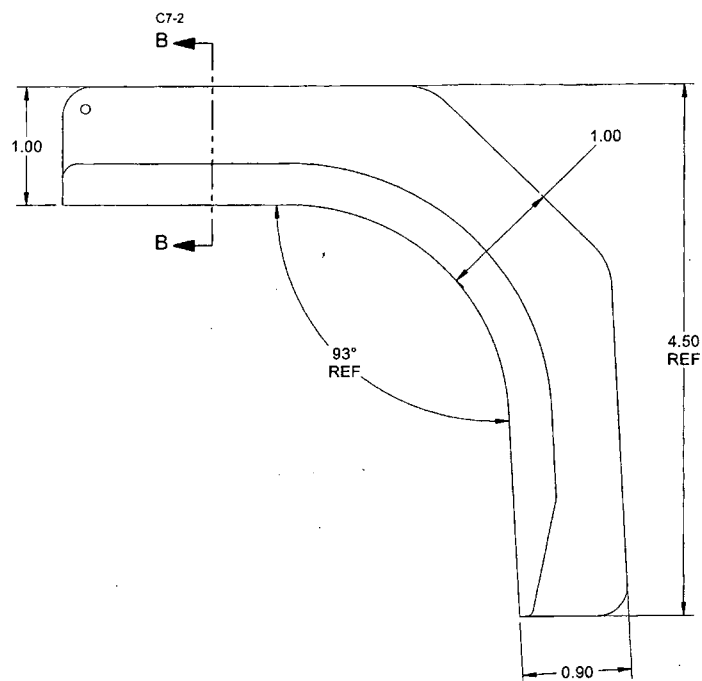
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



79924

RELEASE  
2012-01-17

- NOTES:**  
1) MATERIAL: MAKE FROM D4456-1F FLAT PATTERN  
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
7) WEIGHT: 0.03 lbs  
8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	<del>RF</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>RF</del>	<b>D4456</b>	SHEET 2 OF 8
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	<b>FWD RAINGUTTER, RH</b>	1:1
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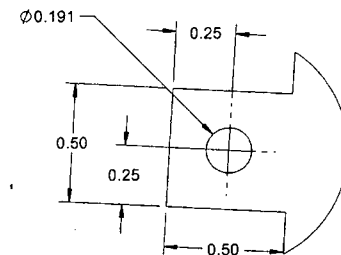
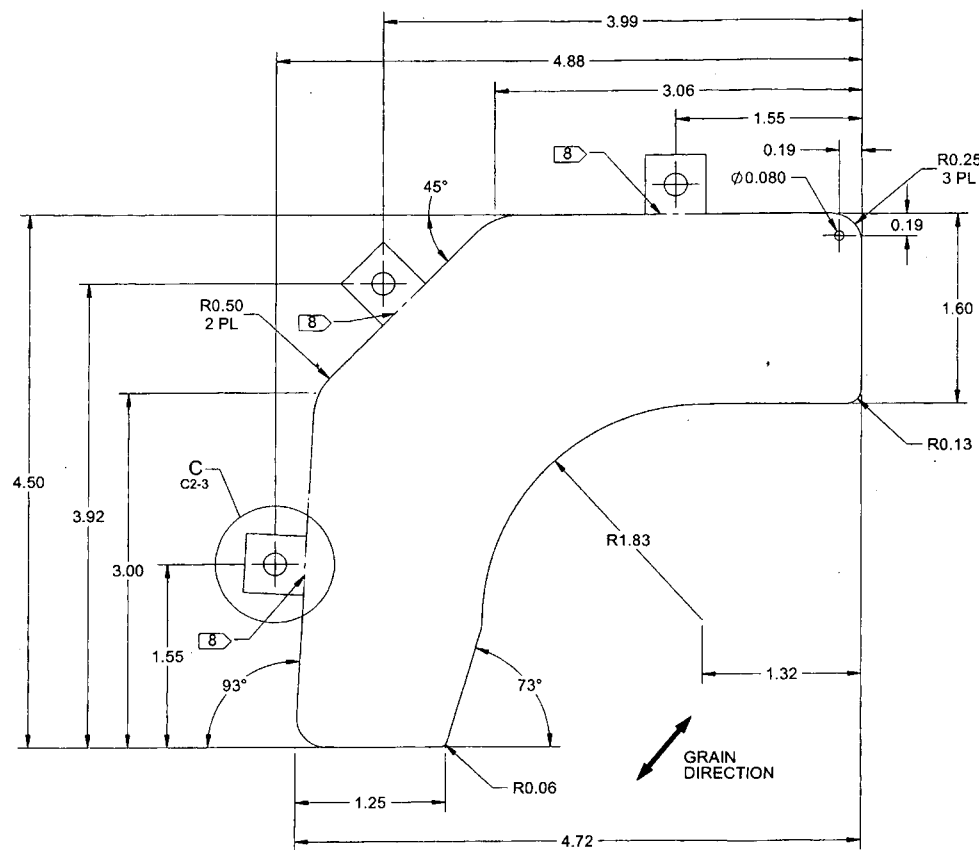
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DETAIL C** C7-3  
TYP C8-3  
D5-3

79924

RELEASED  
2012-01-17  
JW

**D4456-1F FWD RAINGUTTER FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.032 THICK  
PER AMS QQ-A-250/11 OR AMS 4025  
REF DART SPEC M6061-OS.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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MFG. APPR.	<i>[Signature]</i>	<b>D4456</b>	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RAINGUTTER</b>	NTS
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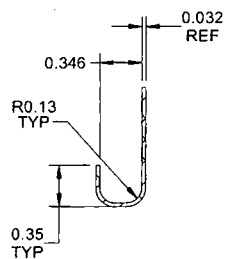
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

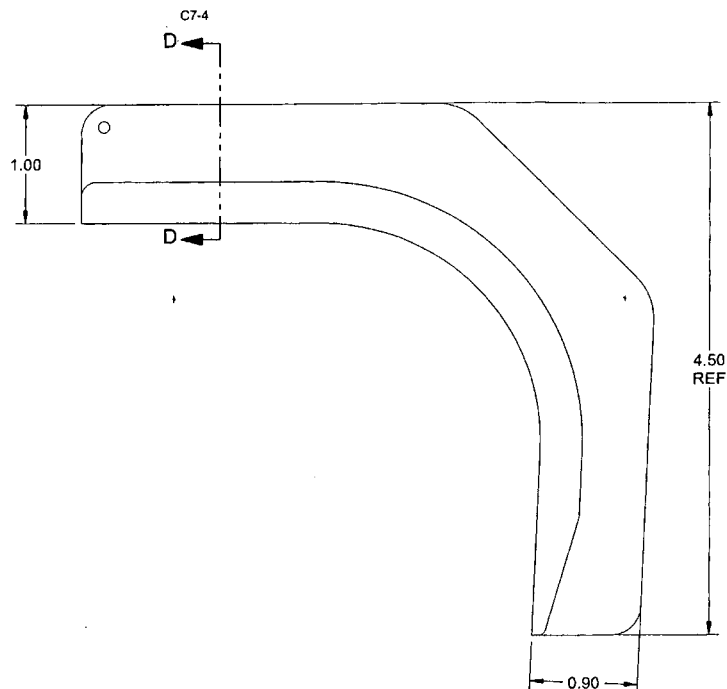
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

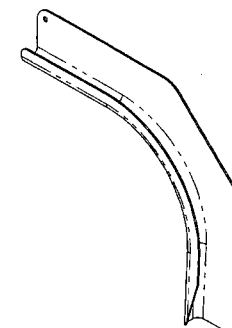
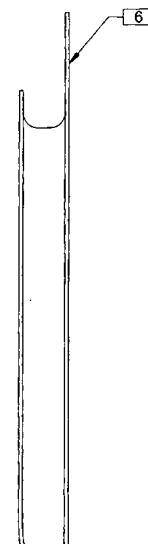
**NOTE:** Date & initial all entries



**SECTION D-D C6-4**



**D4456-3 AFT RAINGUTTER, LH**



79924

RELEASED  
2012-01-17

**NOTES:**

- 1) MATERIAL: MAKE FROM D4456-3F FLAT PATTERN  
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	<i>[Signature]</i>	D4456	SHEET 4 OF 8
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

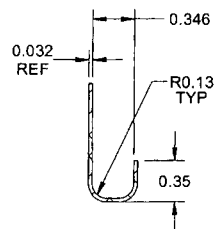
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

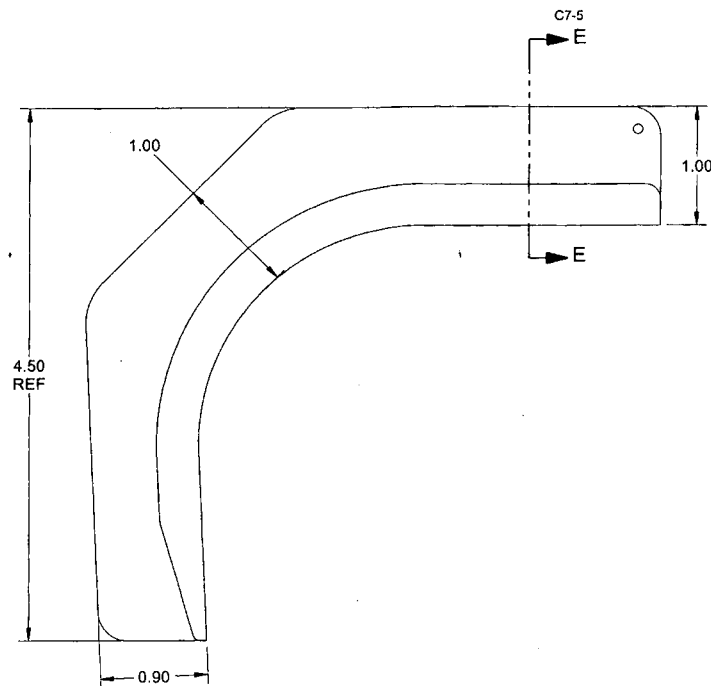
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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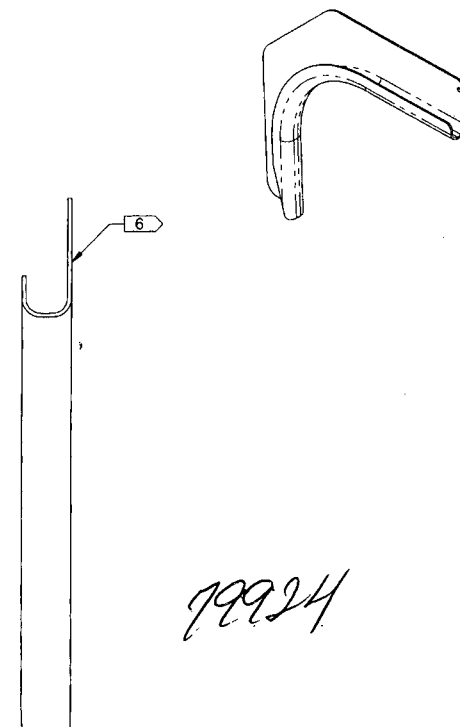




**SECTION E-E** D4-5



**D4456-4 AFT RAINGUTTER, RH**



79924

RELEASED  
2012-01-17

**NOTES:**

- 1) MATERIAL: MAKE FROM D4456-3F FLAT PATTERN  
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



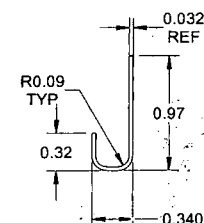
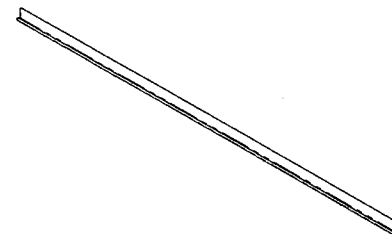
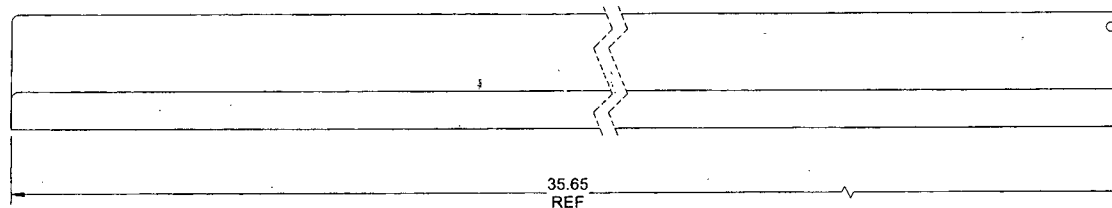
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



79924

**D4456-5 CENTER RAINGUTTER**

RELEASED  
2012-07-17

**NOTES:**

- 1) MATERIAL: MAKE FROM D4456-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4456</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 8	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RAINGUTTER</b>	NTS
DATE	11.11.17	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

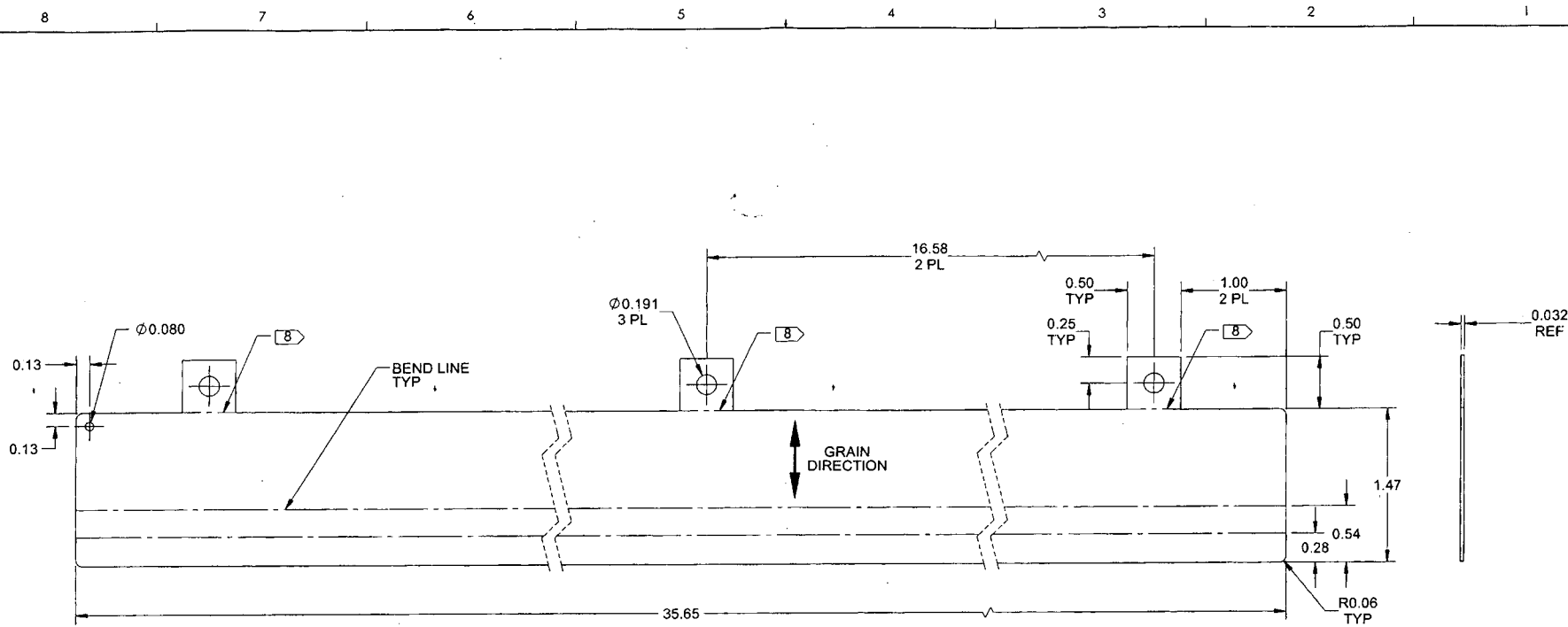
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D4456-5F CENTER RAINGUTTER FLAT PATTERN**

19924  
RELEASED  
2012-01-17

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.032 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. A
MFG. APPR.	<del>RF</del>	D4456	SHEET 8 OF 8
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	RAINGUTTER	NTS
DATE	11.11.17	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC J7R 5A8  
Tel: 450-473-1884 / Fax: 450-491-5498

Recu de Livraison

Order	Shipper	Shipping Seq.
174695	1	59687

Shipped Complete

**Customer** **215**

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

**Shipped To:**

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
PO16523		AL-6061	2012/3/23	FEDEX
Quantity	Part No. / Part Name / Part Description			Pounds

60 D4456-1 5,

← (10) RAINGUTTER

✓ (10) D4456-2 FWD  
RAINGUTTER

✓ (10) D4456-3 AFT  
RAINGUTTER

(10) D4456-4 FWD  
RAINGUTTER

(20) D4456-5 CENTER  
RAINGUTTER

CONTENANT: 1 BOÎTE DE CARTON

Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

<b>PACKING</b>	
----------------	--

Quantity Shipped: 60

Pounds Shipped: 5,00

Quantity Remaining: 0

Pounds Remaining: 0,00

Quantity Shipped: 60

Pounds Shipped: 5,00

Signature:

Date:

Metcor Inc.  
560, boul. Arthur-Sauvé  
St-Eustache (Québec) J7R 5A8  
Tél. : 450 473-1884  
Télécopieur/Fax administration : 450 491-5498  
Télécopieur/Fax production : 450 491-6454



**Certificat de Conformité**  
**Certificate of Compliance**

BON DE TRAVAIL order	CHARGEMENT load
174695	1

CLIENT / client: 218

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO16528		AL-8081		

**SPÉCIFICATIONS DU PROCÉDÉ**

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T6

AGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITÉ	40 - 50 %IACS	50	47 - 48 %IACS
HARDNESS	85 HREW MIN	80	91 - 93.5 HREW

DURETÉE MESURÉE EN HR15TW = 78.2-80.5  
HR15TW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
80	5	D4456-1 (10) RAINGUTTER  (10) D4456-2 FWD RAINGUTTER  (10) D4456-3 AFT RAINGUTTER  (10) D4456-4 FWD RAINGUTTER  (20) D4456-5 CENTER RAINGUTTER  CONTENANT: 1 BOÎTE DE CARTON

COMMENTAIRES / comments

*[Signature]*